

Thursday, January 12, 2017 10:53:17 AM

155294

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 1/16/2017 **Start Qty:** 2.00

~

Customer:

Required Date: 1/23/2017 **Req'd Qty:** 2.00

2

Reference:

Approvals: Process Plan: DAS Date: JAN 13 2017
21

Tooling:

Date:

Run Start *NR1*

QC: 9-39

Date:

SPC (Y/N):

Date:

Stop ***NR2***

**Insp.
Stamp**

0.00

120

FLOW WATER JET

0.13

Waterjet

Memo

FLOW CNC Waterjet

Cut Blank as per File D3167-1 BLANK

130

0.00

130

HAAS CNC VERTICAL MACHINING #1

0.22

HAAS 1

Memo

HAAS CNC vertical machine #1

Note: (2) Bearpaw for (1) Kit
1-Inspect material for defects or damage prior to machining
2-Machine as per Folio FA285 and Dwg D3167
3-Deburr

140

0.00

140

QC2- Inspect parts off machine FAI/FAIB

0.00

OC

Memo

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Thursday, January 12, 2017 10:53:17 AM

Page 1

Work Order ID: 155294

155294

Parent Item: D3167-1

D3167-1

Parent Item Name: Bearpaw

Start Date: 1/16/2017

Required Date: 1/23/2017

Start Qty: 2.00

Required Qty: 2.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	760.9000	3.6	7.2			

MUHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

2017/01/16

Location

Loc Qty

Loc Code

MAT018

760.9

m135913

85.4

m136290

275.5

m136453

400

9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

DART AEROSPACE LTD		Work Order:	155294
Description: Bearpaw		Part Number:	D3167-1
Inspection Dwg: D3167 Rev: A1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.06 x 45°	+0.030/-0.010	0.06345°	✓		vern	mm L-05
B	5.80	+/-0.030	5.793	✓		↓	
C	0.25 x 45°	+/-0.030	0.250 x 45°	✓		↓	
D	R0.25	+/-0.030	0.250	✓		RC	
E	0.200	+/-0.030	.197	✓		vern	mm L-05
F	0.250	+/-0.010	0.245	✓		micro	mm L-01
G	0.625	+/-0.030	0.620	✓		vern	mm L-05
H	0.375	+/-0.010	0.380	✓		↓	
I	0.950	+0.030/-0.010	0.944	✓		↓	
J	3.21	+/-0.030	3.214	✓		↓	
K	19.00	+/-0.030	19.00	✓		tape	
L	Ø0.260	+0.005/-0.000	0.260	✓		vern	mm L-05
M	Ø0.93	+/-0.030	0.927	✓		↓	
N	0.30	+0.030/-0.000	0.308	✓		↓	
O	0.375	+/-0.030	0.375	✓		↓	
P	7.23	+/-0.030	7.237	✓		↓	
Q	4.54	+/-0.010	4.538	✓		↓	
R	2.00	+/-0.030	2.016	✓		↓	
S	12.000	+/-0.010	12.00	✓		tape	
T	6.000	+/-0.010	5.997	✓		vern	mm L-05
U	23.75	+/-0.030	23.75	✓		tape	

Measured by:	DAS 49	Audited by:	DAS 33	Prototype Approval:	N/A
Date:	12/01/20	Date:	17/01/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D130-700-011	KJ/RF	

DART



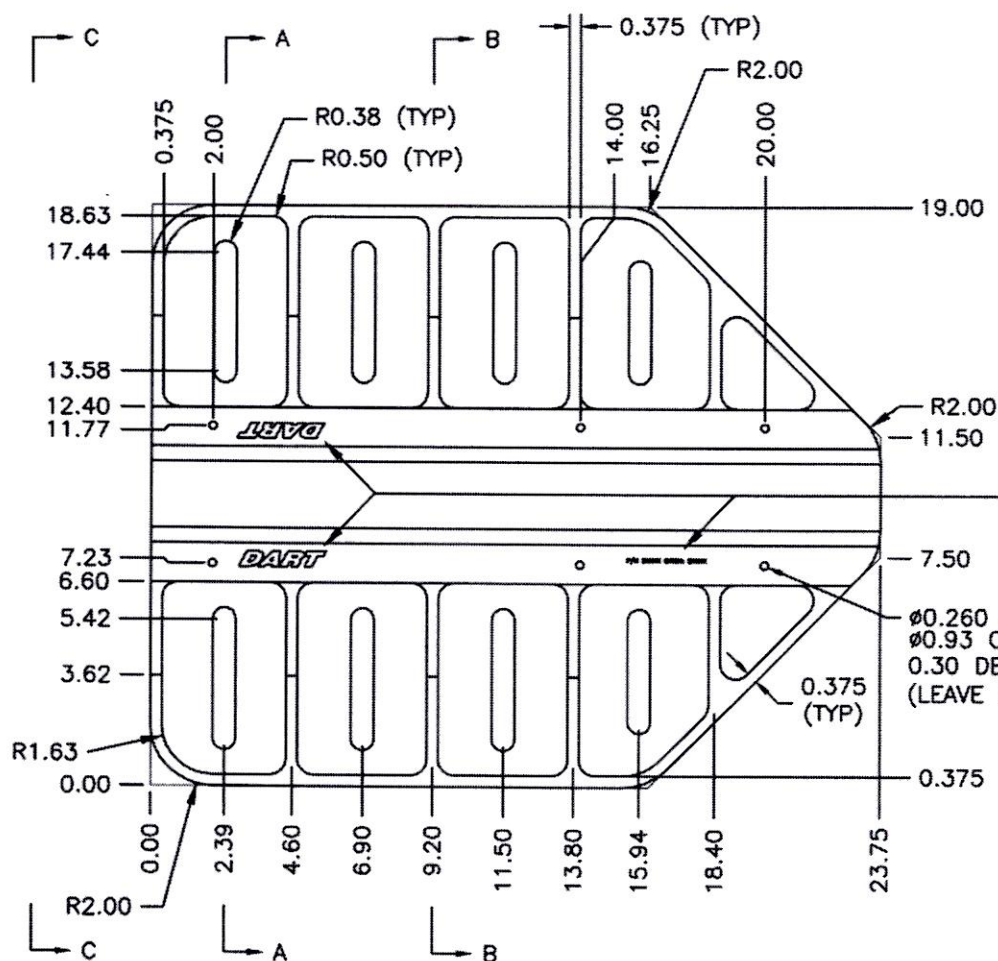
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02.10.25

DESIGN		DRAWN BY		DART AEROSPACE LTD	
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA	REV. A
DATE	02.10.08	DRAWING NO.	D3167	TITLE	SHEET 1 OF 2
				BEARPAW	SCALE
					1:6
A	02.10.08	NEW ISSUE			
A1	02.12.17	5.80 WAS 5.50			

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 155294 MJS
1701-13



D3167-1

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

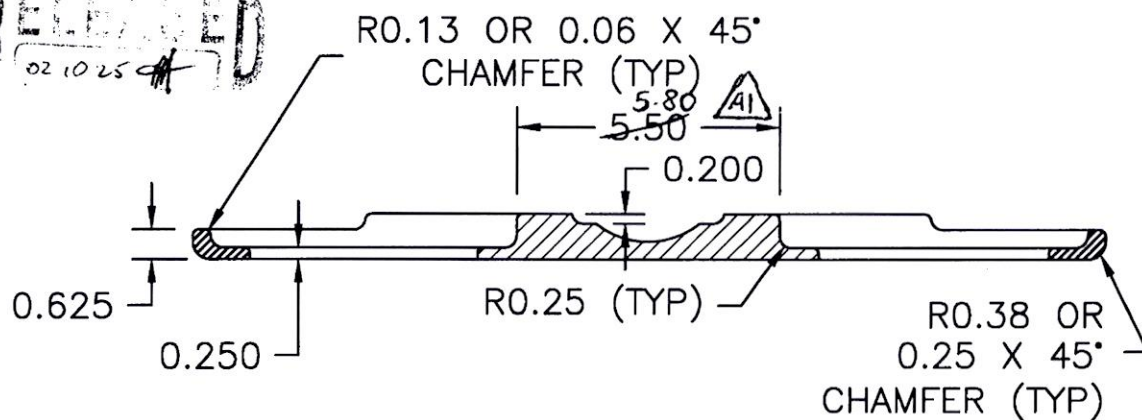
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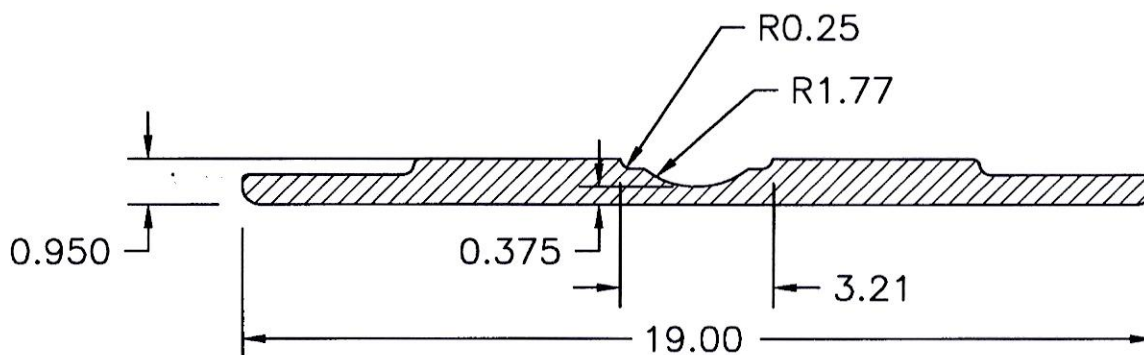


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CHECKED 	APPROVED 	DRAWING NO. D3167	REV. A SHEET 2 OF 2
DATE 02.10.08		TITLE BEARPAW	SCALE 1:4

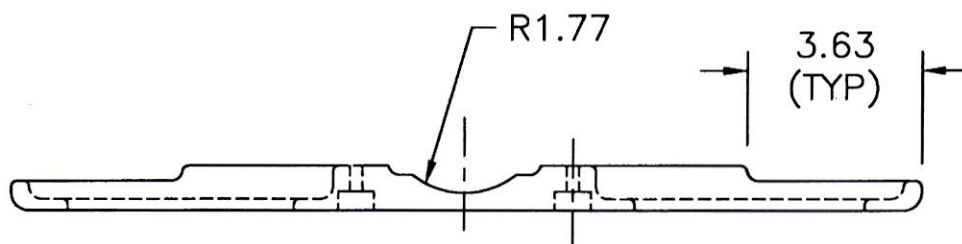
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SECTION A-A



SECTION B-B



SECTION C-C

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